

# Work Order ID 53129

October 23, 2009 8:01:56 AM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 23/10/2009 Start Qty: 2.00



Cont Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: *24-10-23*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3836	Rev A
-------	-------

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836-2- remove identification markings-3- deburr

PD 09.10.23 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*2) 8-10-23*

*(-041)*

*(+2)*

*f*

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-2- weld D2327-3 spacer bushing as per dwg D3836-3 A/R ER316 S.S. Rod Batch: *71109213* -3- grind weld flush where indicated on dwg D

PD 09.10.24 (2)

**Work Order ID 53129**

Page 2

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Start Date: 23/10/2009 Start Qty: 2.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*lpc 07 10 27*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*→ S on 10/27**(041)**(12)*

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*SY 09/10/27**(24)*

**Work Order ID 53129**

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October 23, 2009 8:01:56 AM

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 23/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/18 JA

MF  
09-10-27

# Picklist Print

October 23, 2009 8:02:01 AM

Page 1

Work Order ID: 53129

Parent Item: D3836-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)


Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	46.0000	2.0000			
												

Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46

44274

27

44365

9

51126

10

M304TS0.750W.065

Purchased

No

100

f

468.3119 3.7491



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

468.3118947

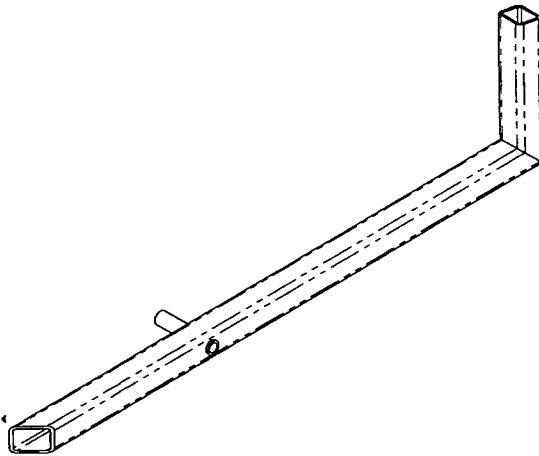
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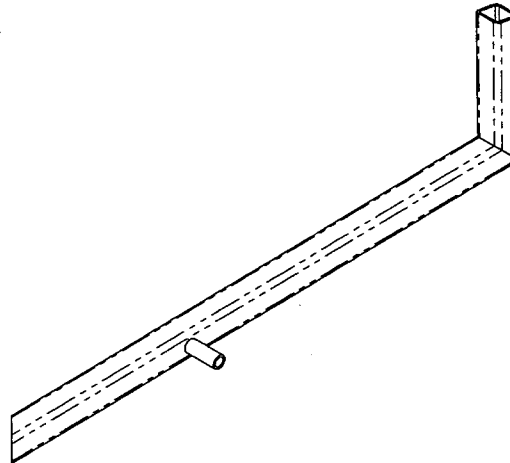
② PD 09.10.24

PD 09.10.23

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

SHOP COPY  
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SUBJECT TO AMENDMENT,  
WITHOUT NOTICE  
WORK ORDER

NO. 53129  
PL 0910-23

**RELEASED**  
06/11/12

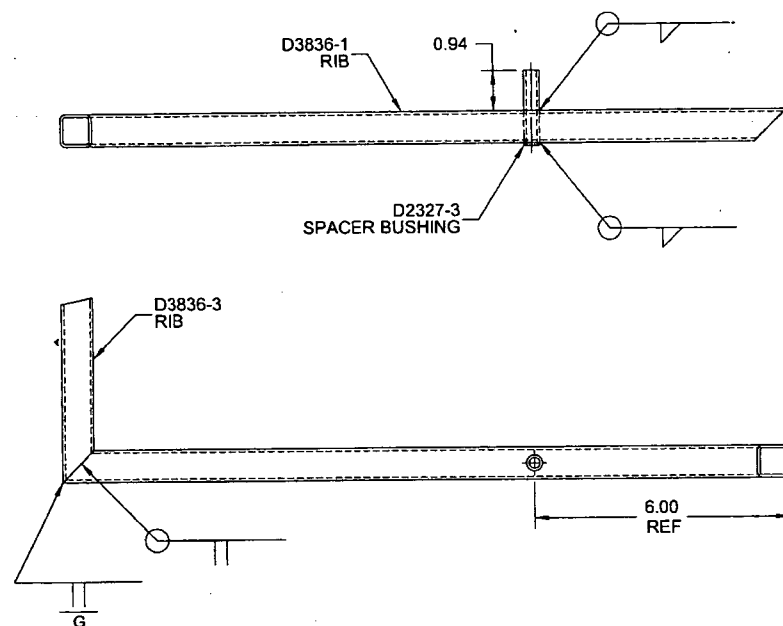
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MATERIAL: N/A  
FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: 0.99 lbs EACH  
WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

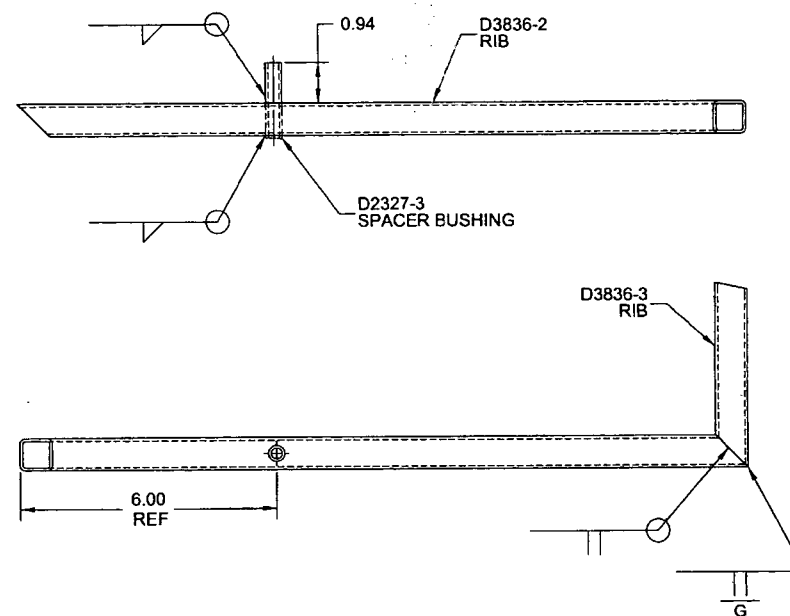
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3836** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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**D3836-041 RIB ASSY (BASKET LID, LH)**



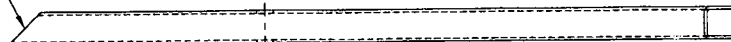
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WORK ORDER  
NO. 53129

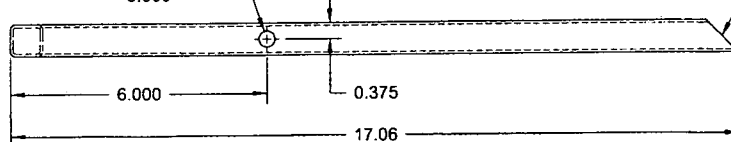
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0.75 X 45°  
CHAMFER

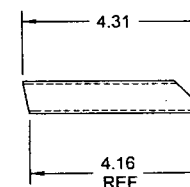


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



**D3836-1 RIB**

0.75 X 45°  
CHAMFER



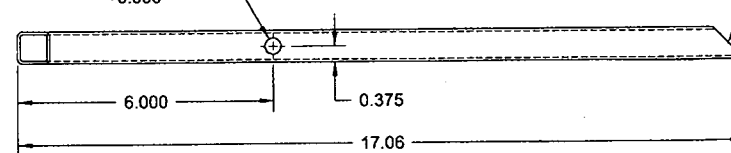
**D3836-3 RIB**

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WORK ORDER  
NO. 53129

0.75 X 45°  
CHAMFER

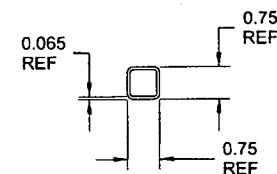


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



**D3836-2 RIB**

0.75 X 45°  
CHAMFER



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/13

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

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CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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